



Dart Aerospace Ltd.
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D2891-1
Job Sheet R204782



Part No: D2891-1

Job Qty: 2 pcs

Part Name: Support 2.25



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/19/19

Job Tracking No: ECN19-1307

Due Date: 1/10/20

Created By: Linda Lacelle

Type: Rework

Description:

Note: DWG D2891 REV C IPP C 08.03.19 Re-format EC verified:DD/IPP Rev:E 11.08.04 as per dwg rev.B DD
verf:EC/IPP Rev.F 19.12.02 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
101	Rework - 1 - Startup	2 pcs		1/10/20	0.00	0.00	Crosstubes - 1		
							Crosstubes - 2		
							Crosstubes - 3		
							Crosstubes - 4		
105	Rework - 2 - B4B	2 pcs		1/10/20	0.00	0.00	HAAS - 1 - 5 - B4B		
110	QC 2	2 pcs		1/10/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

DAS
41 DEC 19 2019
1902 2020/01/08

DAS
64
9-89



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Container No: S242278



Part: D2891-1

Job No: R204782

Serial No/Batch: S242278

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/19/19

DAS
64
9-89

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	MM. 2020/01/28
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120 QC 8	2 pcs	1/10/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	SBL 20/01/29
				QC 8 - 76	
				QC 8 - 61	
130 Crosstubes - 2 - B4B	2 pcs	1/10/20	0.00 0.09	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	DAS
				Crosstubes - 4 - B4B	41 FEB 05 2020
140 QC 3	2 pcs	1/10/20	0.00 0.00	QC 3 - 10	3-89
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	FEB 06 2020
				QC 3 - 19	
					DAS 40 9-89

				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B 2 pcs	1/10/20	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	DAS 84 9-82
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS
180 QC 21 - SA 2 pcs	1/10/20	0.00 0.00		QC 21 - SA - 21	21
				QC 21 - SA - 70	9-82
				QC 21 - SA - 53	
Part Op 101 - Pick and bring to machining. Descriptions: 105 - Rework per Rev C. 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Crosstubes - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. 5206999 exp 8/21 140 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ LOCATION : LG052 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2891-1	Support 2.25	2 pcs (1 ea)	101-Rework - 1 - Startup	5236352	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
101-Rework - 1 - Startup	D2891-1	2	2	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	2.250 Support	0.188Inches ± 0.000	0.000 0.188	
2	2.250 Support	0.240Inches ± 0.000	0.000 0.240	
3	2.250 Support	0.115Inches ± 0.000	0.000 0.115	
4	2.250 Support	0.040Inches ± 0.000	0.000 0.040	
5	2.250 Support	0.010Inches ± 0.000	0.000 0.010	
6	2.250 Support	0.240Inches ± 0.000	0.000 0.240	
7	2.250 Support	0.290Inches ± 0.000	0.000 0.290	
8	2.250 Support	0.115Inches ± 0.000	0.000 0.115	
9	2.250 Support	0.454Inches ± 0.000	0.000 0.454	
10	2.250 Support	2.779Inches ± 0.000	0.000 2.779	
11	2.250 Support	0.240Inches ± 0.000	0.000 0.240	
12	2.250 Support	1.002Inches ± 0.000	0.000 1.002	
13	2.250 Support	0.053Inches ± 0.000	0.000 0.053	
14	2.250 Support	0.257Inches ± 0.000	0.000 0.257	
15	2.250 Support	1.663Inches ± 0.000	0.000 1.663	
16	2.250 Support	0.053Inches ± 0.000	0.000 0.053	
17	2.250 Support	0.022Inches ± 0.000	0.000 0.022	

Plex 12/19/19 11:07 AM dart.lacelle.linda